



Dart Hawkesbury
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K6A 1K7
Canada

Tel (613) 632-5200

D2596
Job Sheet 168476



Part No: D2596

Job Qty: 12 ea

Part Name: Web, 205 Skidtube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/15/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV D IPP: D 99.02.02 Changed QA to QC, Added Step 6 and Cost DM IPP Rev:E 07-07-09
Incorporated DEO 9183 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		11/23/17	0.00	0.00	Start Up Skidtubes		
100	Skidtubes	12 pcs		11/23/17	0.00	6.38	Skidtubes		
110	HandFinish	12 pcs		11/24/17	0.00	3.15	HandFinish1		
120	QC	12 pcs		11/24/17	0.00	0.00	QC5		
130	Packaging	12 pcs		11/24/17	0.00	0.00	Packaging3		
140	QC21-SA	12 Ea		11/24/17	0.00	0.00	QC21		

Part Op 100 - 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per
Descriptions: Dwg D2596 4- Deburr

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2500-3-100 B147804	12	36	0	0

Part Specifications

Specifications could not be found.

Plex 11/15/17 11:09 AM dart.poulin.mario

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Skid- Mach Thermofo Larg
Date :		Step #:		QTY
Description Work Order Deviation				
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		
		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		
		Temperature ☐ Set-up ☐ BOM/Route ☐ Broken/Darr ☐ Inspection Ir ☐ Contaminati ☐ Countersink ☐ Cut Too Short ☐ Instructions Ir ☐ Drill Holes ☐		
		OTHER :		

PART NO: D2596
Revision:
Operation: Start up Operation
Change No:
Mfg Date:

Mig Date: 11/24/17
Job No: 168476

Web, 205 Skidtube

2ART
AEROSPACE
5013506

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other	

2) Approval

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Supervisor
Verification

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Dimensions
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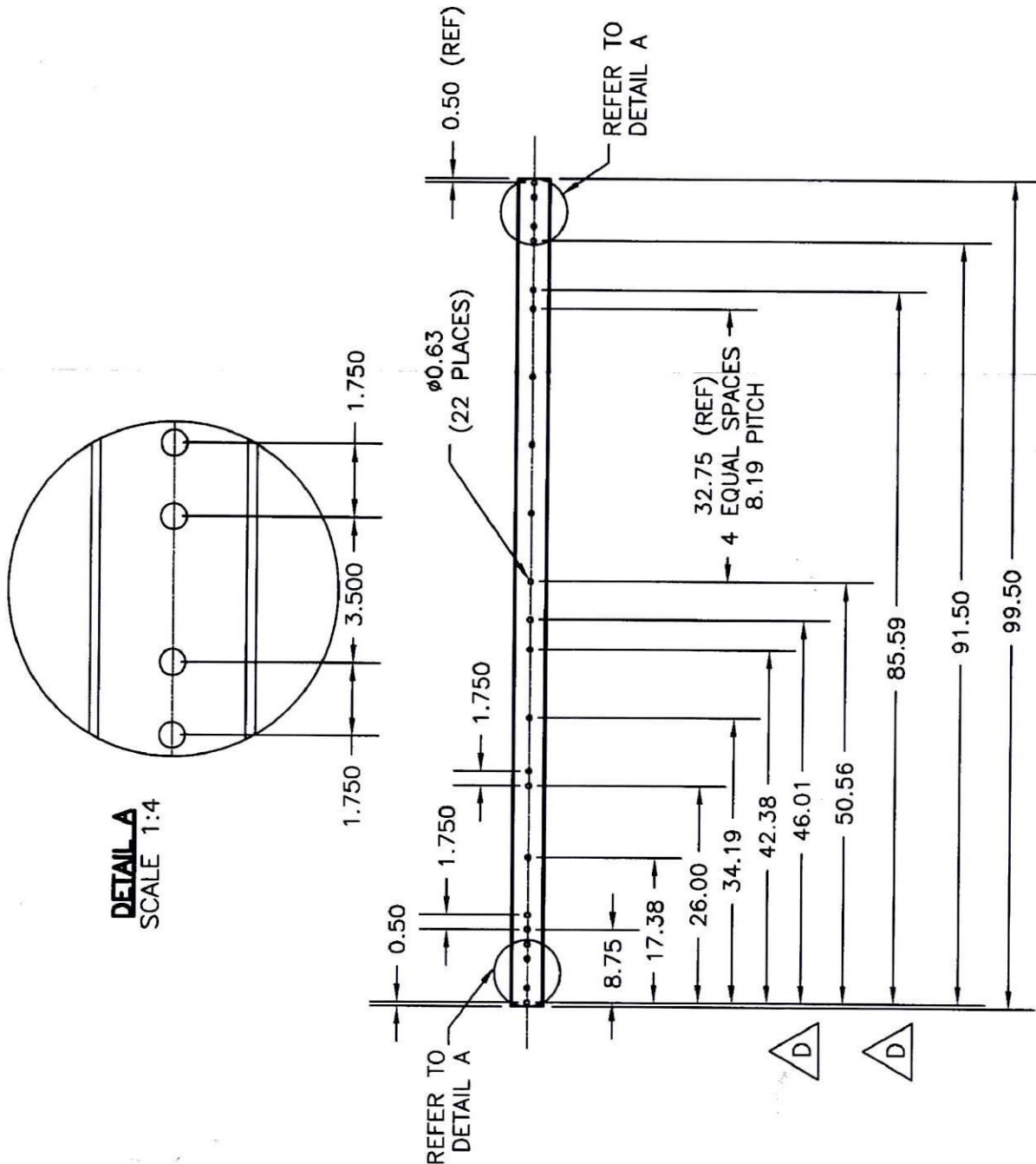
Misaligned
Fit/Function
Misaligned/off center

Misread
Turning Sequence



DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1
DATE 07.04.17	TITLE 205 WEB		SCALE 1:20
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	

RELEASED
07.06.18



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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